Friday, 9/21/2007 1:01:03 PM

User.

Kim Johnston

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 34788

Estimate Number

: 10173

P.O. Number This Issue

: NA : 9/21/2007

S.O. No. : NA

: 33815

: MACHINED PARTS

Part Number

Drawing Number

Drawing Name

· D2537 REV A1 : N/A

: BUSHING

: D2537

10/8/2007

Project Number **Drawing Revision**

Material Due Date

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

: Est

Material change on Step 2 KJ/JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304R500

0.500" 304 SS roundbar



Comment: Qty.:

0.1203 f(s)/Unit Total:

6.0165 f(s)

Material: AISI 304/316 Round Bar Ø0.500"(M304R.500)

Batch: M105261

20

HARDINGE



Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA273

2-Deburr and Tumble

JP07/10/29

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK





Comment: SECOND CHECK

PACKAGING RESOURCE #1



PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:__

Dart Aerospace Ltd

	WORK ORDER CHANGES								
STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
	STEP	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr			

Part No: _	PAR #:	Fault Category:	_ NCR: Yes No DQA:	Date: <u>MK13</u>
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section E	3	Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						Ē.		

NOTE: Date & initial all entries

Date:

Friday, 9/21/2007 1:01:03 PM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 34788

Part Number: D2537

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 87-10-30

Dart Ae	rospace L	.td								
W /O:			W	ORK ORDER CH	IANGES					
DATE STEP		PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							`			
		,								10
·····										
Part No:		PAR #:	Fault Cate	gory:	NCI	R: Yes I	No DQA	۸:	_ Date: _	
						QA: N/	C Closed	l:	_ Date: _	
NCR:			WORK ORD	ER NON-CONFO	DRMANCE	(NCR)			***************************************
DATE	OTED	Description of NC	Corrective Action Section B				Verification		Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Section		Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34788		
Description: Bushing	Part Number:	D2537		
Inspection Dwg: D2537 Rev: A1		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.010	1.250				
0.316	+0.005/-0.000	1.250 0.3165 0.438				
Ø0.438	± 0.005/-0.0 00	0.438				
	7-010					
						,
ž.						

Measured by:	Audited by:		Prototype Approval:	N/A
Date: 07/10/29	Date:	1/10/29	Date:	N/A

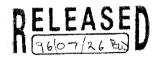
Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue	KJ/RF	-1
В	05.02.17	Added Ø0.438	KJ/JLM A	. (11)



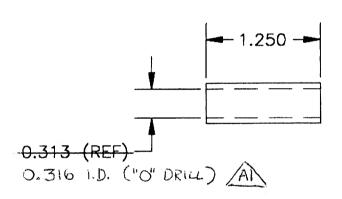




ſ	DESIGN B WILLIAMS	DRAWN BY B WILLIAMS		AEROSPACE INTERNATIONAL AIRPORT.					
r	CHECKED	APPROVED	DRAWING NO.			RE	EV.	A	
	M. M.	B6>	D2537		SHEET	1	OF	· 1	ı
t	DATE		TITLE			S	ĆΑ	E	
	96:05:15		BUSHING				1	1:1	١
T	Al 02.0	8.30 OP A	0,316 WAS	0,3/3					







SHOP COPY RETURN TO ENGINEERING

MATERIAL: 304/316 SS 7/16 OD 0.063 WALL UNCONTROLLED COPY

SUBJECT TO AMENDMEN OR 0.065 WALL

WITHOUT NOTICE KE 81.09.07